



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE-350DAMPER-05
Job Sheet 197434



Part No: RBE-350DAMPER-05

Job Qty: 20 pcs

Part Name: Pin



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/8/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/2/19

Description:

Type: Stock

Note: DWG RBE-350DAMPER REV:1 IPP REV:A 18.01.16 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Conventional Lathe - 1	20 pcs	9/2/19	9/2/19	0.50	2.00	Conventional Lathe - 1		
							Conventional Lathe - 2		
110	QC 2	20 pcs	9/2/19	9/2/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S201833



Part: RBE-350DAMPER-05

Job No: 197434

Serial No/Batch: S201833

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 07/31/19

Plex 7/8/19 1:07 PM Dart.lajeunesse.marie

120	QC 8	20 pcs	9/2/19	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	DAS
					QC 8 - 52	52
					QC 8 - 23	9-89
					QC 8 - 57	1707/31
130	Packaging 3-1 - Stock - B4B	20 pcs	9/2/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	MV
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	

				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	20 pcs	9/2/19	0.00 0.00	QC 21 - SA - 21	DAG 21 AUG 02 2019
				QC 21 - SA - 70	1-SS AUG 07 2019
				QC 21 - SA - 53	

Part Op 100 - (Manufacture as per dwg), 1-Machine as per folio FB _____ FOLIO REV: _____ DWG REV: _____

Descriptions: _____ 2-Debur

110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

130 - (Identify as per dwg & Stock Location: _____), IDENTIFY AND STOCK

140 - (QC21- Final Inspection - Work Order Release)

W A002

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
3009A237	Pin	3 ft (0.0625) ft each	100-Conventional Lathe - 1	5184201 / 5199607 GA060
<i>With 1-3009A237 you make 4 pieces!</i>				

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Conventional Lathe - 1	3009A237	5	1	0

Part Specifications	
Specifications could not be found.	

Plex 7/8/19 1:07 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	197434
Description: Pin		Part Number:	RBE-350Dampener - CS
Inspection Dwg: Same as P/N	Rev: 1		Page 1 of 1

INSPECTION SHEET

[illegible]

Measured by:	Checked by:	QC Inspector:
Date:	Date:	Date:

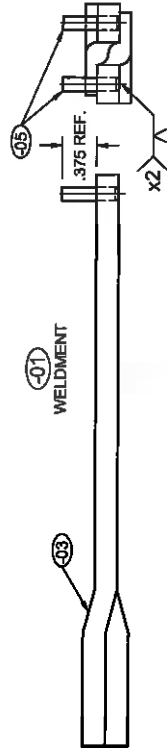
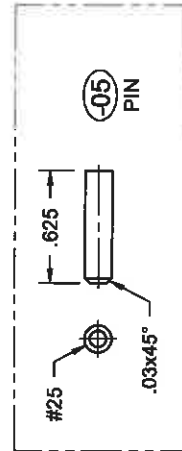
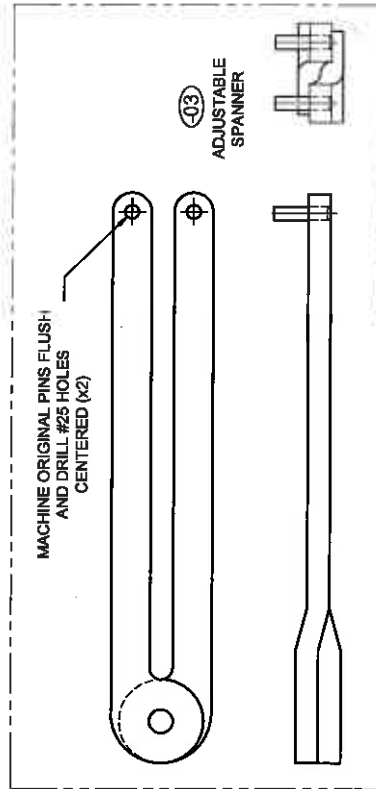
Engineering Approval: (If necessary)		Date:
--	--	--------------

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS		DESCRIPTION		DATE	INITIAL	APPROVED
1	DESIGNED PER HEU PRODUCTS TOOLS.			9/9/09	WP	DW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197434 MJS
19-0408



FUNCTION: USED TO REMOVE DAMPER CAP

RED BARN MACHINE	
DAMPER SPANNER WRENCH	
DWG NO.	RBE-350DAMPER
REV	1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	
XXX ± .005	
XX ± .01	
X ± .02	
FRACTIONS ± 1/32	
ANGLES ± .5°	
HEAT TREAT	
BLACK OXIDE	
USED ON MODEL	
EUROCOPTER AS350/355	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 X 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE	NTS
DATE	9-9-09
SHEET	1 of 1



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	
Part No. _____	Scrap ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	
	Use-as-is ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐	
				Quality ☐	
Date: _____		Sequence #: _____		MRB (QS1042) ☐	
Description Work Order Deviation		Disposition			
		QTY Affected: _____			
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details: _____				